

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018664**Date Inspected:** 23-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Tian Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

Heat straightening of PCMK, E2-SB1-001, under approved Heat Straightening procedure, HSR 1(B)-9389, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhang Ya Xu. The approved HSR procedure stated that a maximum temperature of 650°C, with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 8mm.

Bay 2

This QA Inspector observed the following work in progress for Bay 2.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhang Ya Xu.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam

PCMK: FB3343-001-037

Welder: 066236, 067876, 068859

Report: B-WR17366

WPS-345-FCAW-2G (2F)-Repair-1

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Components: Segment Assembly
PCMK: SEG3020L-169
Welder: 048696, 045276, 045240
Report: B-WR17523
WPS-345-FCAW-1G (1F)-Repair-1

PCMK: SEG3020K-265
Welder: 045268
Report: B-WR17474
WPS-345-SMAW-3G (3F)-Repair-1

Heat straightening of PCMK, SA3448-001, SA3446-001, LD3049-001, under approved Heat Straightening procedure, HSR 1(B)-9873, 9874, 9828, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhang Ya Xu. The approved HSR procedure stated that a maximum temperature of 600°C, 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 6mm, 8mm, 9mm.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as follows; Floor Beam FB3343-001 on Item number 1 of NWIT tracker document # 07470,

Bay 3

This QA Inspector observed the following work in progress for Bay 3.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhang Ya Xu.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam
PCMK: FB3286-001-334,338
Welder: 055491
WPS-B-T-2233-TC-U4b-F

PCMK: SEG3019K-135
Welder: 052696
Report: B-WR17328
WPS-345-FCAW-3G (3F)-Repair-1

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
